

Work Order ID 159525

Wednesday, April 12, 2017 3:06:13 PM

159525

Page 1

Item ID: D2332-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lid Prop Assembly 6.69"
Start Date: 4/13/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 4/20/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference: (P.A.)SCHEUDLED/S

Approvals: Process Plan: DAS 21 Date: APR 12 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2332	Rev C1 ✓								

100

0.00

100

Small Fab

Small Fab

Memo

1.46

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

6 Ø 17-4-18 **DAS 19 9-89**

110

0.17

110

Brake NC

Brake NC

Memo

0.57

Punch and form D2332-11 to length as per dwg D2332 using DT8012
(need 2 per ass'y)

6 Ø 17-4-18 **DAS 19 9-89**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00				6	0	17-4-19	DAS 19 9-89
120									
Small Fab	Memo	0.84							
Small Fab	1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y)								
	2- Ensure no foreign objects inside tube								
	3- Deburr								
130	QC5- Inspect part completeness to step on W/O	0.00				6			DAS 38 9-89
130									APR 19 2017
QC	Memo	0.12							
Quality Control									
140		0.00				6			
140									
Large Fab	Memo	0.66							DYC
Large Fab	Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y) *****ensure nothing is inside of tube before welding*****								17/04/20
	S.S Rod batch: 134442								

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
2A0 27 60-C								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.12				<u>6</u>			DAS 38 9-89 APR 26 2017
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>SB67</u> Memo	0.00 0.06				<u>6</u>			APR 26 2017 DAS 9-89
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.60							17/4/27 JF DAS 21 9-89

Dr 2017/04/26

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due				FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center						☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
OTHER : _____											

Picklist Print

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Work Order ID: 159525

159525

Parent Item: D2332-041

D2332-041

Parent Item Name: Lid Prop Assembly 6.69"

Start Date: 4/13/2017

Required Date: 4/20/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B02.08.12Re-format; Incorporated D2332-13/-11/-7/-5KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-4A *AN4-4A* BOLT		Purchased	No			170	Each	23.0000	1	6		APR 25 2017	DAS 19 9-89

Location	Loc Qty	Loc Code
over003	20	
m137061	20	
ST346	3	
m129390	3	

M304R.250 *M304R 250* 304 SS Round bar .250		Purchased	No			100	f	14.3369	0.1	0.631579		17-4-19	DAS 19 9-89
---	--	-----------	----	--	--	-----	---	---------	-----	----------	--	---------	-------------------

Location	Loc Qty	Loc Code
MAT028	14.336915	
m133368	3.020915	
m135249	11.316	

M304TR0.500W.035 *M304TR0 500W 035* 304 RD Tube .500 x .035W		Purchased	No			110	f	69.2697	1.25	7.894737		17-4-19	DAS 19 9-89
--	--	-----------	----	--	--	-----	---	---------	------	----------	--	---------	-------------------

Location	Loc Qty	Loc Code
GA	69.26974	
m137086	40.15474	
m137199	9.115	
m137286	20	

5.994
1.99

7.984

DQA: _____ Date: _____



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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By 		
							Lead hand / Supervisor Approval Verification 		
							QC / QA Coordinator Approval 		

Root Cause				FAULT CATEGORY			
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
☐ Past Expiry Date	☐ Manufacturing Process	OTHER : _____					
☐ Misidentified	☐ Past Due						

Picklist Print

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Work Order ID: 159525

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Parent Item: D2332-041

D2332-041

Parent Item Name: Lid Prop Assembly 6.69"

Start Date: 4/13/2017

Required Date: 4/20/2017

Start Qty: 6.00

Required Qty: 6.00

M304TR1.000W.049

Purchased

No

100

f

28.2474

0.43

2.71579

**

DAS
19
9-89

M304TR1 000W 049

304 RD Tube 1.00 x .049W

17-4-19

Location

Loc Qty

Loc Code

GA002

28.247449

125250

28.247449

2.72

MS21042L4

Purchased

No

170

Each

853.0000

1

6

**

APR 25 2017

DAS
19
9-89

MS21042L 4

Nut

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

154

m135058

154

ST303

689

m136986

189

m137166

500

6

NAS1149D0416J

Purchased

No

170

Each

3,666.000

3

18

**

APR 25 2017

DAS
19
9-89

NAS1149D0416.J

WASHER

Location

Loc Qty

Loc Code

GA

723

m131511

723

ST264

2943

m131511

2943

18

DQA: _____ Date: _____



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